

Appl. No. 09/622,082  
Amdt. Dated November 14, 2003  
Reply to Office Action of July 16, 2003

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**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claims 1-7 (Cancelled).

8. (Currently Amended) A method for layering of an admixture in a web former unit of a board machine in which two or more webs are formed by means of separate web former units, each comprising a gap former, and then combined with one another to form a multi-layered web, comprising the steps of:

dividing a flow of fresh stock into at least two component stock flows;

adding of an admixture to a selected one of the at least two component stock flows;

passing said at least two component flows into a multi-layer headbox; and

passing said at least two component flows from said headbox into a gap former;

wherein said selected one of said at least two stock flows is used for forming a first web, said first web having a face that will be placed against and combined with a face of a second web, said admixture being added for increasing a fines content in said first web and increasing the bonding strength between said combined faces of said first and second webs; and

wherein the speed of the board machine is higher than 1000 meters per minute.

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9. (Previously Presented) A method according to claim 8, wherein said admixture includes starch, fines, fillers, retention agents, hydrophobifying sizes and special chemicals.

10. (Previously Presented) A method according to claim 8, wherein said fresh stock flow is branched into three separate component flows and said admixtures are added to at least one of said component flows.

11. (Previously Presented) A method according to claim 8, wherein said admixture is added in an upper-wire unit.

12. (Previously Presented) A method according to claim 8, wherein said admixture is added at one of a point before a pump, a point after said pump, and a point after a machine screen in said board machine.

13. (Previously Presented) A method for the manufacture of board in which two or more webs are formed by means of separate web former units and then combined with one another to form a multi-layered web, comprising the steps of:

discharging at least one layer of stock having an admixture from at least one multi-layer headbox to a gap former for forming a first paper web;  
combining said first paper web with at least a second paper web formed by one of a

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separate multilayer headbox and normal headbox; and  
wherein a speed of said machine is higher than 1000 meters per minute.

Claims 14-15 (Cancelled).

16. (Currently Amended) A method for application of a layer of admixture in the web former unit of a board machine in which two or more webs are formed by means of separate web former units, each comprising a gap former, and then combined with one another to form a multi-layer web, comprising the steps of:

dividing a flow of fresh stock into at least two component stock flows;  
adding admixtures to at least one component stock flow that will form a face that will be placed against and combined with the face of the web formed by another web former unit, wherein said adding step increases the contents of fines in the layers and the bonding strength between the faces;

inserting said admixtures at at least one of a point before a pump, a point after the pump, and a point after a machine screen;

passing the component flows into the multi-layer headbox and further into the gap former;  
and

wherein the speed of the board machine is higher than 1000 meters per minute.

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17. (Previously Presented) A method as claimed in claim 16, wherein the admixture includes starch, fines, fillers, retention agents, hydrophobifying sizes, and special chemicals.

18. (Previously Presented) A method as claimed in claim 16, wherein the fresh stock flow is branched into three separate component flows, of which the admixtures are added to at least one component flow.

19. (Previously Presented) A method as claimed in claim 16, wherein said component stock containing said admixture is applied to said web face in an upper-wire unit.